

Date: Friday, 02/05/2008 2:56:41 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY
Job Number	: 39019		
Estimate Number	: 12631		
P.O. Number	:	Part Number	: D2127251905
This Issue	: 02/05/2008 S.O. No. :	Drawing Number	: D212-725-1 PG10
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 02/05/2008 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31025	Material	:
Written By	:	Due Date	: 09/05/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JLD 08.52</u>		
Comment	: Est Rev:A New Issue 07-01-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W
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Comment: Qty.: 3.1500 f(s)/Unit Total : 6.3000 f(s)

304 RD Seamless Tube 1.0" x .049W

Batch: M107573

FF 08-05-05

2

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D212-725-1 & Template DT8907

FF 08-05-05

2

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08-05-05 (2)

4.0	MS2081916J	Sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Sleeve

Batch: M10764923 / M10420321

FF 08-05-05

(2)

5.0	AN81816J	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104715

FF 08-05-05

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 2:56:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 39019

Part Number: D2127251905

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Flare and Install Sleeves & Nut as per Dwg D212-725-1.

FF 08-05-06

(2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/06 x2

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pc 8/5/6 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/06 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-06

Dart Aerospace Ltd

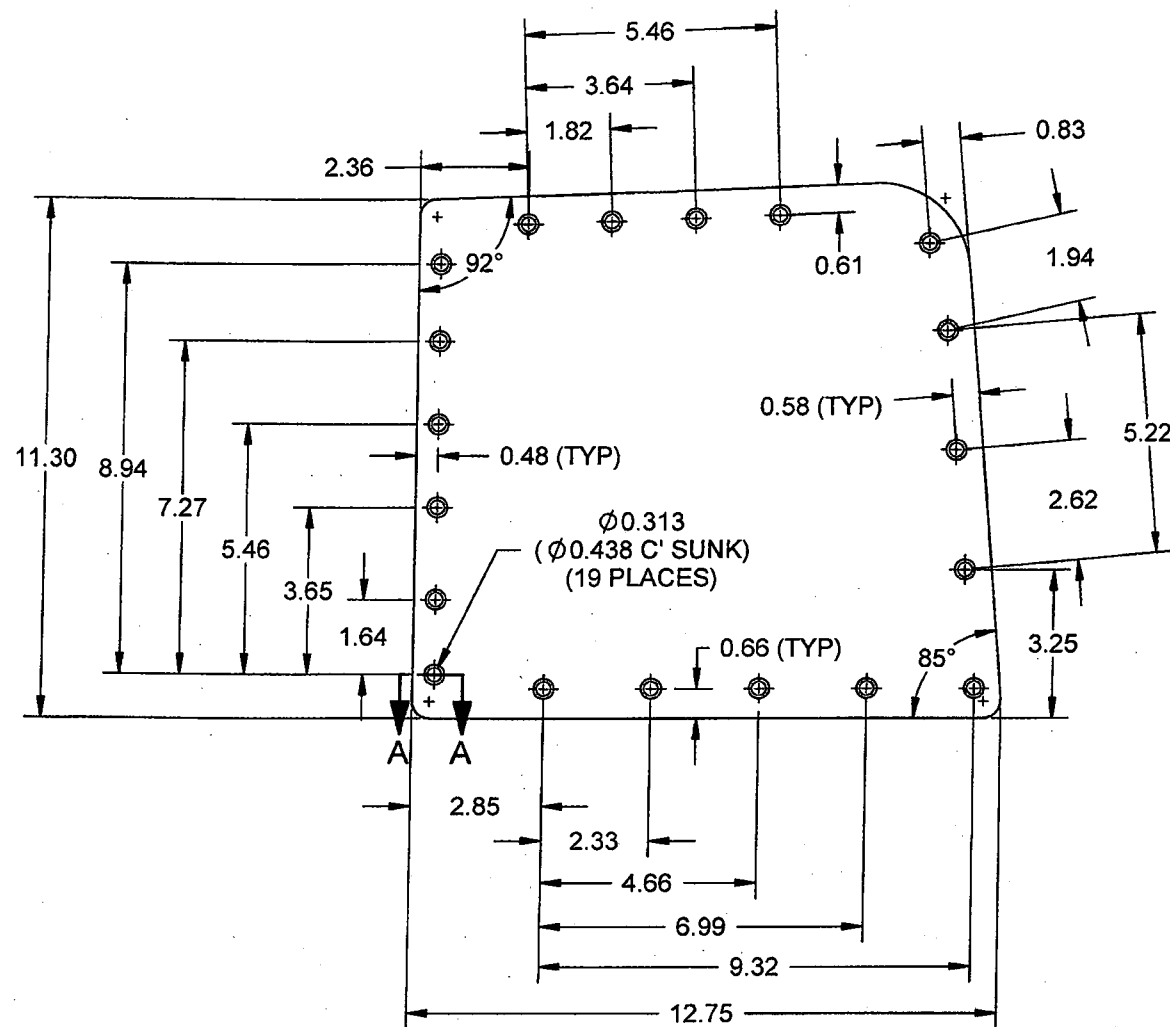
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

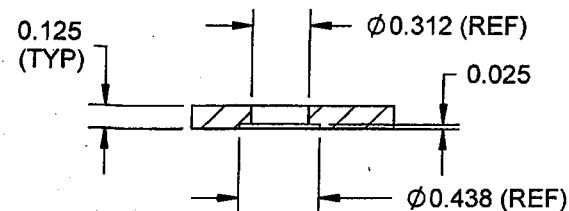
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



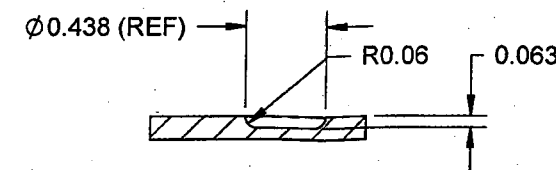
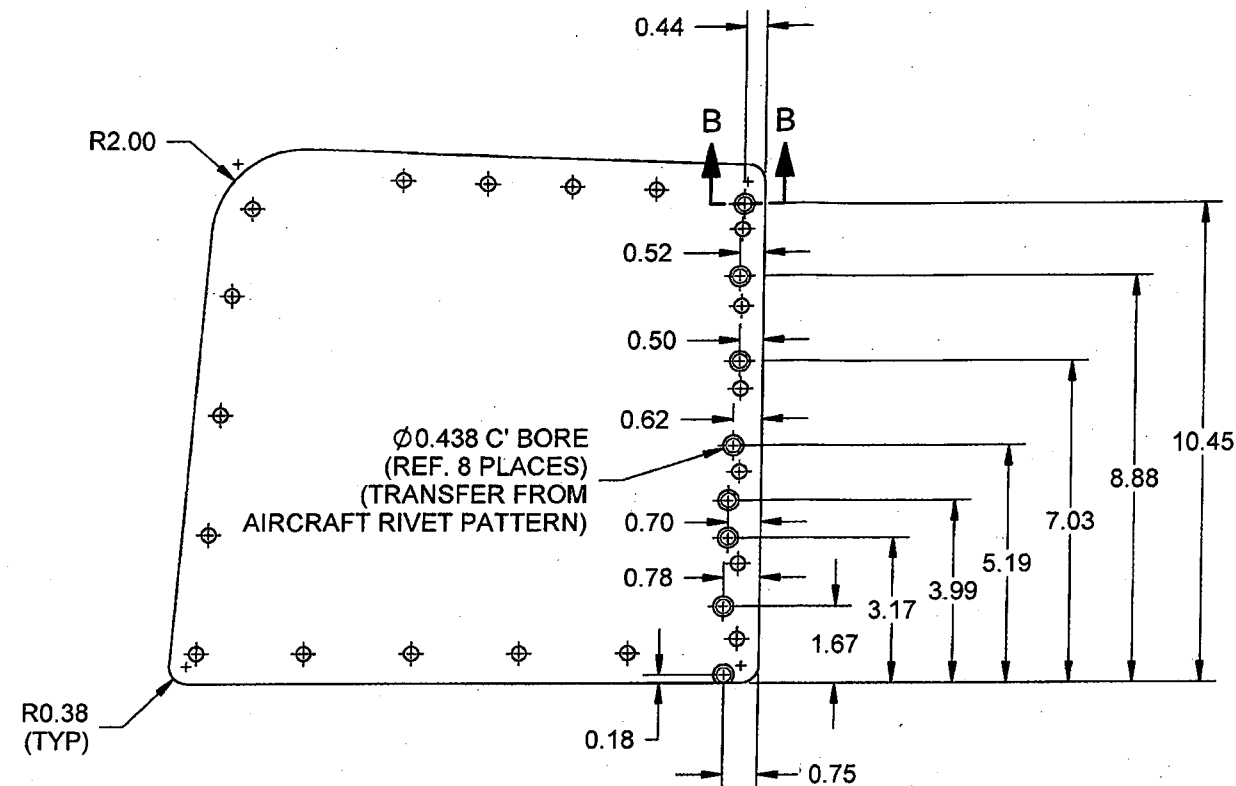
DIMENSIONS BETWEEN HOLES ARE PROVIDED FOR REFERENCE ONLY
TRANSFER $\phi 0.313$ HOLES FROM AIRCRAFT



SECTION A-A
(19 PLACES TOP SIDE)
SCALE 1:1

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.125 THICK, (REF. DART SPEC. M2024T3S.125)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

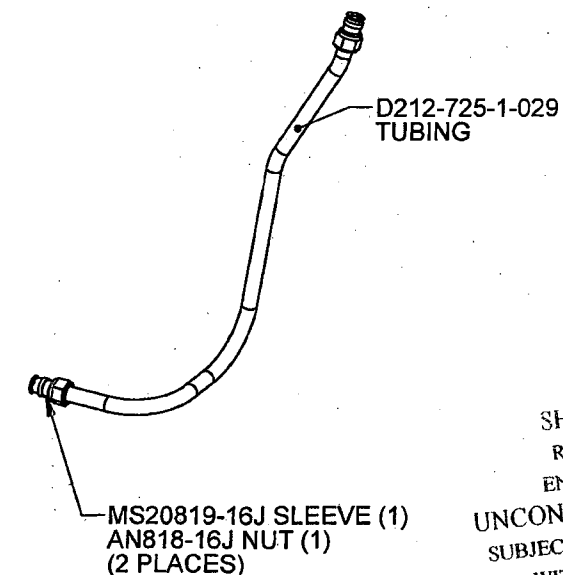
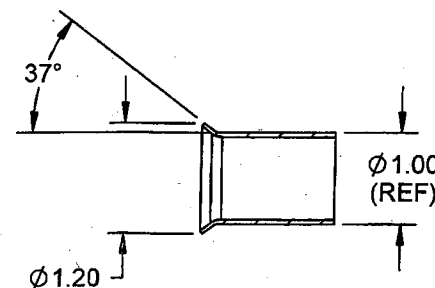
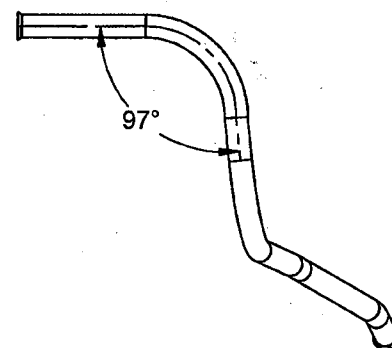
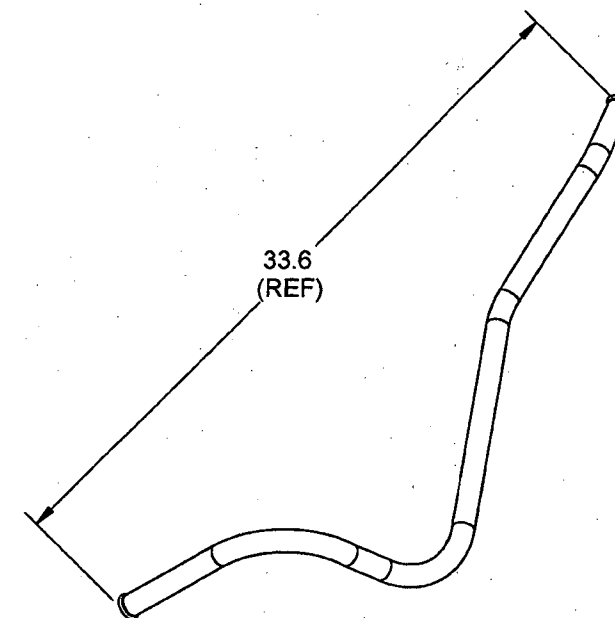
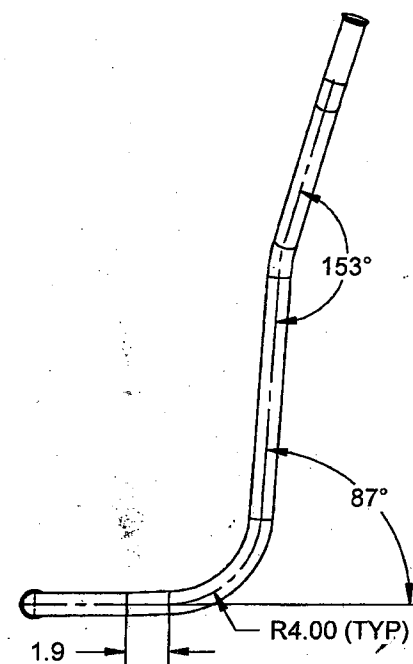
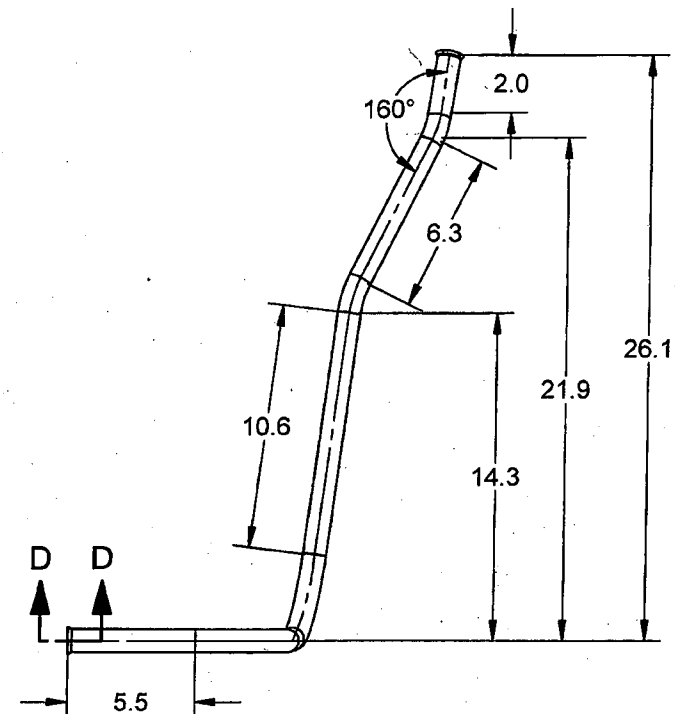


SECTION B-B
(8 PLACES BACK SIDE)
SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39019

D212-725-1-001 PANEL (SHOWN)
D212-725-1-002 OPPOSITE

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 1 OF 44 SCALE 1:4
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D212-725-1-029 TUBING
MANUFACTURE PER TEMPLATE DT8907

NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL 1.00 O.D. x 0.049 WALL (REF. DART SPEC. M304TR1.000W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SECTION D-D
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 1:2
(2 PLACES)

D212-725-1-905 TUBE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39219

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED 	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 10 OF 44 SCALE 1:8
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